



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 74441**

Page 2

Thursday, September 29, 2011 2:41:35 PM

Item ID: D3286-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/29/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

Form as per Dwg D3286

0.00

SB 11/10/17



140



QC5- Inspect part completeness to step on W/O

0.00

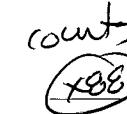
QC

Quality Control

Memo

0.00

SW 11/10/17



150

Identify as per dwg & Stock Location LG

0.00

Packaging

Packaging

Memo

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

0.00

11/10/17 SF 88

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Thursday, September 29, 2011 2:41:35 PM



Page 3

Item ID: D3286-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/29/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

11/10/18 JG

Memo

0.00

MF 11-10-18

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NOTE: Date & initial all entries

## Picklist Print

Thursday, September 29, 2011 2:41:42 PM

Page 1

**Work Order ID:** 74441



**Parent Item:** D3286-1



**Parent Item Name:** Doubler

**Start Date:** 9/29/2011

**Required Date:** 10/20/2011

**Comments:** IPP A□04.07.14□New issue□KJ/JLM□  
IPP Rev:B Now on Waterjet 06-06-16 JLM

**Start Qty: 80.00**

**Start Qty: 80.00**

**Required Qty: 80.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	144.4000	0.0749	6.307368	6.5		BU1-10-6

304/316 0.125 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	144.4	
117494	16.4	
119006	64	119006
119048	64	

86

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74441
Description: Doubler	Part Number:	D3286-1
Inspection Dwg: D3286	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-10-7	Date: 11/10/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.11.07	New Issue	KJ/JLM <i>AF</i>	<i>EE</i>

Dart Aerospace Ltd

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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

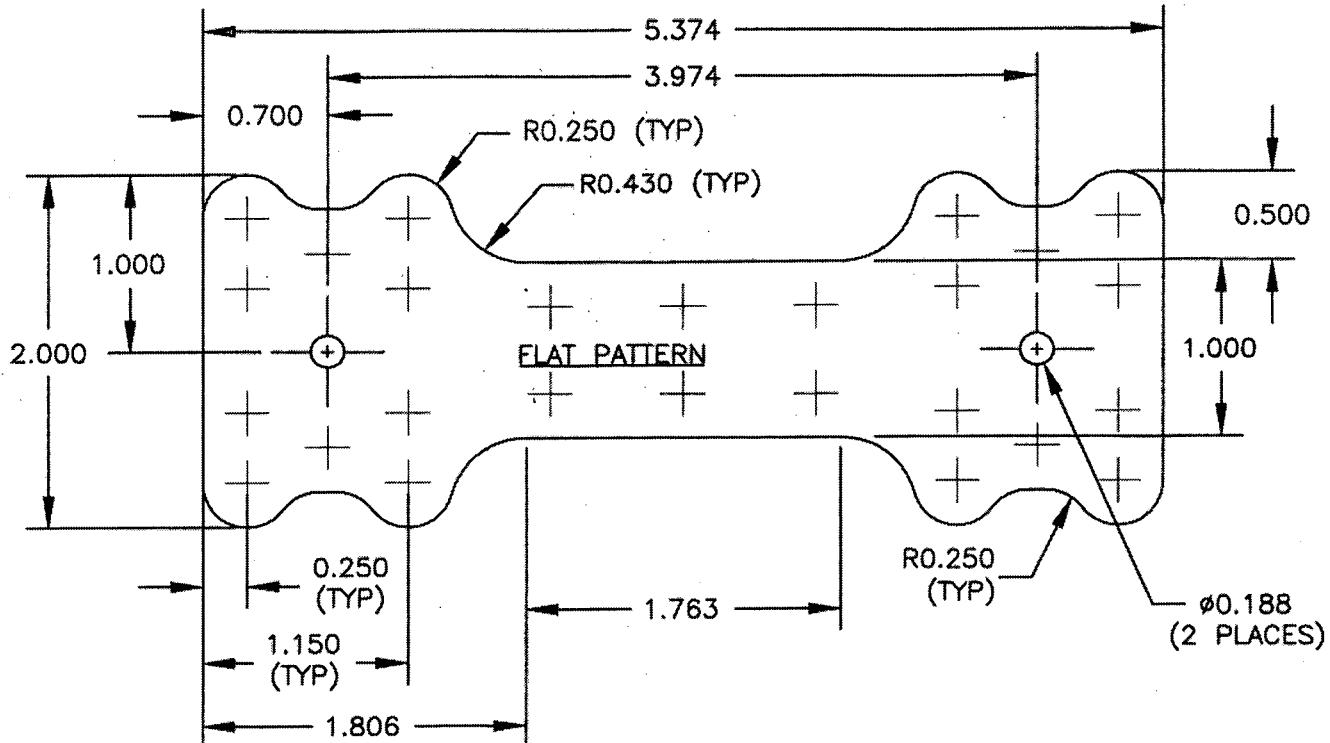
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3286
DATE		REV. A SHEET 1 OF 2
04.05.06		TITLE GROUND HANDLING PARTS SCALE 1:1

A 04.05.06 NEW ISSUE



INDICATES LOCATION OF RIVET  
HOLES. SHOWN FOR REFERENCE  
ONLY, DO NOT DRILL.

BENDING DETAIL

R1.51

RELEASER  
04.06.22

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74441

M.L.J

9/29/11

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK  
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

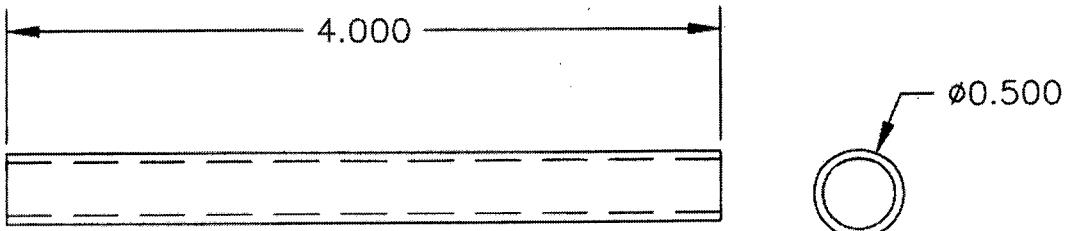
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3286 REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS SCALE 1:1



### D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.06.22 C

lhht

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